



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4149-041
Job Sheet 179721



Part No: D4149-041

Job Qty: 8 ea

Part Name: Aft Crosstube Lug Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 6/29/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP
Rev:C 11.03.03 as per revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	8 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Small Fab-3		6	JUN 29 2018
100	Small Fab	8 pcs	6/29/18	6/29/18	0.00	2.00	Small Fab-6		9-89	DAS 38
110	QC	8 pcs	6/29/18	6/29/18	0.00	0.00	QC5		5-43	DAS 6
120	Packaging	8 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		21	9-89 JUL 1 2018
130	QC21-SA	8 Ea	6/29/18	6/29/18	0.00	0.00	QC21		21	9-89 JUL 1 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	16 Ea (2 ea)	90-Start up Operation	
AN4C13A	Bolt	24 Ea (3 ea)	90-Start up Operation	
D3910-1	Crosstube Lug	8 Ea (1 ea)	90-Start up Operation	
D4091-1	Mounting Lug	8 Ea (1 ea)	90-Start up Operation	
D4149-1	Crosstube Lug Plate, Aft	16 Ea (2 ea)	90-Start up Operation	
D4149-3	Spacer	8 Ea (1 ea)	90-Start up Operation	
D4149-5	Eyebolt Stud	8 Ea (1 ea)	90-Start up Operation	
MS20615-4M18	Rivet	24 Ea (3 ea)	90-Start up Operation	
MS21043-3	Nut	16 Ea (2 ea)	90-Start up Operation	
MS21043-4	Nut	24 Ea (3 ea)	90-Start up Operation	
NAS1149C0332R	Washer	32 Ea (4 ea)	90-Start up Operation	
NAS1149C0432R	Washer	48 Ea (6 ea)	90-Start up Operation	



Container No: S088532



Part: D4149-041

Job No: 179721

Serial No/Batch: S088532

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/29/18

* AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C12A	16	110	0
	AN4C13A	24	125	0
	D3910-1	8	25	0
	D4091-1	8	52	0
	D4149-1	16	49	0
	D4149-3	8	0	0
	D4149-5	8	6	0
	MS20615-4M18	24	66	0
	MS21043-3	16	721	0
	MS21043-4	24	597	0
	NAS1149C0332R	32	5,349	0
	NAS1149C0432R	48	1,935	0

Part Specifications

Specifications could not be found.

Plex 6/21/18 7:27 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004023	S083410	AN3C12A	Bolt	s068653	ST349	16
004023	S083409	AN4C13A	Bolt	s078166	ST344	24
004023	S083402	D3910-1	Crosstube Lug	s071259	ST525	8
004023	S083403	D4091-1	Mounting Lug	s067530	ST525	8
004023	S083404	D4149-1	Crosstube Lug Plate, Aft	s067085	ST080	16
004023	S088528	D4149-3	Spacer	S083426	ST080	8
004023	S055674	D4149-5	Eyebolt Stud	S055673	ST081	6
004023	S088527	D4149-5	Eyebolt Stud	S088524	ST081	2
004023	S088529	MS20615-4M18	Rivet	S083540	ST306	24
004023	S083408	MS21043-3	Nut	s034415	ST302	16
004023	S083407	MS21043-4	Nut	s062296	ST302	24
004023	S083405	NAS1149C0332R	Washer	s049837	ST266	32
004023	S083406	NAS1149C0432R	Washer	s050052	ST266	48

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/29/18 12:45 PM dart.quirion.sonia